

28

DART AEROSPACE LTD	Work Order:	19365
Description: Spacepod Hardware Kit	Part Number:	K10018
-1		
Dwg: D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C	Qty:	7 Kits
03.04.30		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: K10018 Kit to be made in multiples of 7. (1) K10018 requires (2) D2174-041. (1) D2174-041 consists of (1) D2174-1 Web & (2) D2175 Angle	KJ	03.06.30	7
2	MV	Cut blanks: (12.000" x 3.850") Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) Use stack of 7 Identify for D2174-1 Batch: _____			
3	MV	Cut (2) blanks per (1) K10018 Kit Cut blanks: (12.200" x 2.960") grain along 2.960 Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) Use stack of 7 Identify for D2175 Batch: _____			
4	MV	Machine D2174-1 as per Folio FA097 and Dwg D2174-1 Identify as D2174-1			
5	QC2	Inspect parts as they come off the CNC machine			
6	MV	Deburr for measurement			
7	QC8	Second check			
8	MV	Machine D2175 as per Folio FA083 and Dwg D2175 Identify as D2175			
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr for measurement			
11	QC8	Second check			
12	GA	Deburr D2174-1 and D2175 stacks			
13	GB	Form D2175 Angle as per Dwg D2175			
14	QC5	Inspect work to Step 13			
15	FP	Chemical Conversion Coat per QSI 005 4.1 and Dwg D2174-1 and D2175			
16	QC3	Inspect work to Step 15			
17	GA	Assemble D2174-1 and D2175 as per Dwg D2174-041 Pick: Qty Part Number Description Batch 23 MS20470AD4-6 Rivet _____ Identify as D2174-041			
18	QC5	Inspect work to Step 17			
19	FP	Powder Coat White (Ref: 4.3.5.1) as per QSI 005 4.3			
20	QC3	Inspect Powder Coat. Go to KP cell for packing.			

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#:_____ Fault Category:_____ DQA:_____ Date:_____

NOTE: Date & initial all entries
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QA: N/C Closed:_____ Date:_____

DART AEROSPACE LTD		Work Order:	
Description: Spacepod Hardware Kit		Part Number:	K10018
Dwg: D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C		Qty:	Kits
RF 03.04.30		Page 2 of 2	

03.05.15

Step	Location	Procedure	By	Date	Qty																																																
21	KP	<p>Pick: Packing Kit (Note: D2174-041 is not on the BOM, but is in as material from steps 2 & 3)</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D2174-041</td><td>Web Assembly</td><td>B16562 B13732</td></tr><tr><td>1</td><td>D2985</td><td>Decal</td><td>B14160</td></tr><tr><td>8</td><td>A3235-020-935</td><td>Washer</td><td></td></tr><tr><td>16</td><td>AKS7-1032-130</td><td>Insert</td><td>M11912</td></tr><tr><td>8</td><td>AN3-3A</td><td>Bolt</td><td>M3155</td></tr><tr><td>8</td><td>AN3H4A</td><td>Bolt (or AN3H4)</td><td>M12493</td></tr><tr><td>36</td><td>AN525-10R7</td><td>Screw</td><td>M11377 M11822</td></tr><tr><td>8</td><td>AN960JD10</td><td>Washer</td><td>M13063</td></tr><tr><td>16</td><td>AN960JD10L</td><td>Washer</td><td>M12749</td></tr><tr><td>16</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M12241</td></tr><tr><td>8</td><td>MS24694S67</td><td>Screw</td><td>M9404</td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	D2174-041	Web Assembly	B16562 B13732	1	D2985	Decal	B14160	8	A3235-020-935	Washer		16	AKS7-1032-130	Insert	M11912	8	AN3-3A	Bolt	M3155	8	AN3H4A	Bolt (or AN3H4)	M12493	36	AN525-10R7	Screw	M11377 M11822	8	AN960JD10	Washer	M13063	16	AN960JD10L	Washer	M12749	16	MS21042L3	Nut (or -3)	M12241	8	MS24694S67	Screw	M9404	SB	03-07-02	7
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22	QC4	Inspect Kit 100% for Completeness on the W/O	Q	03-07-02	1.																																																
23	ST	Identify and Stock	SB	03-07-02	7																																																
24	AC	Cost / part 61.26	SHE	03-07-03	7																																																
25	DC	Close W/O 61.30 Inspect Level 21	Q	03.01.03																																																	

Rev	Date	Change	Revised By	Approved
A	03.03.26	New issue	KJ/RF	#

RELEASED
03.04.30

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

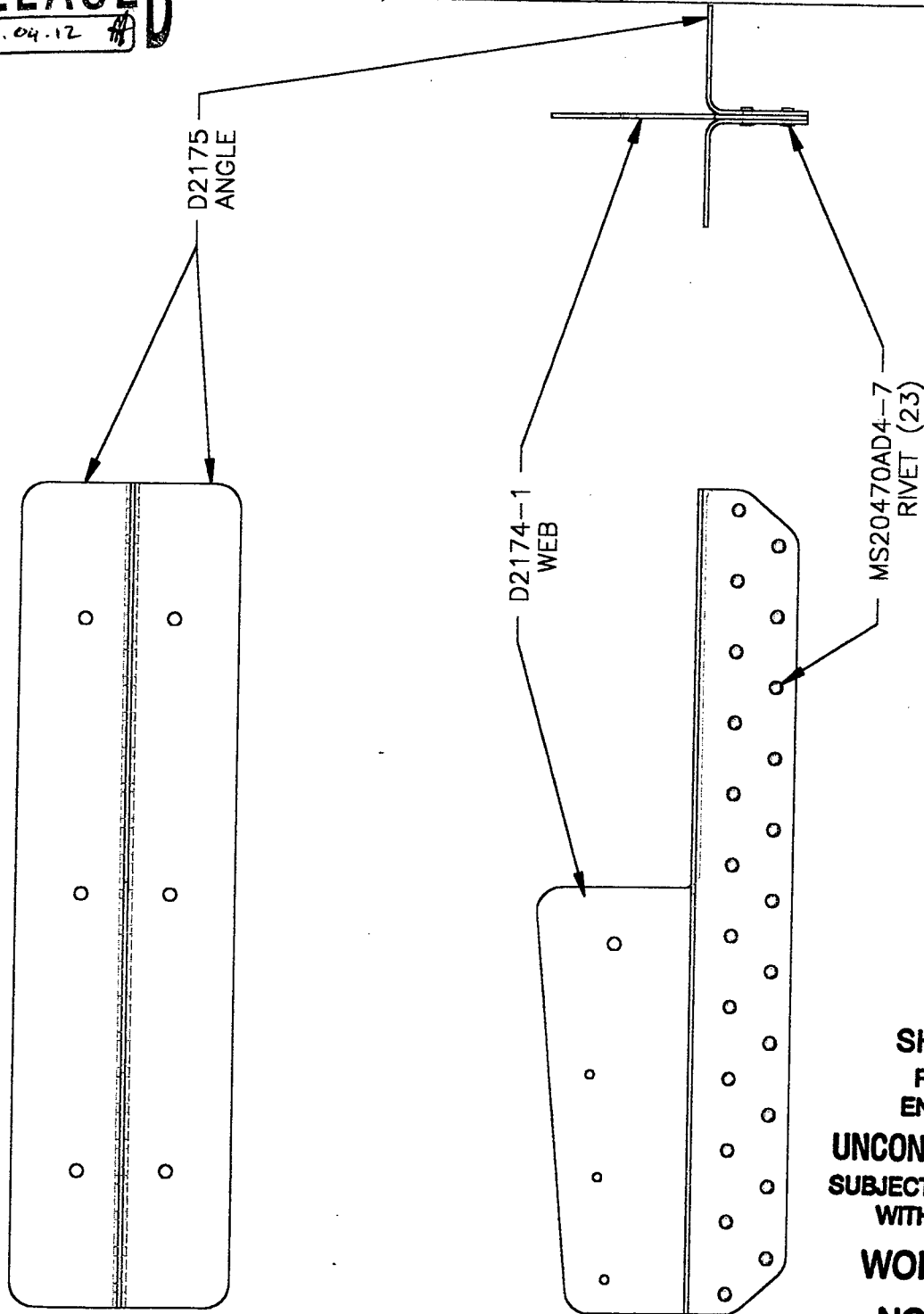
PAR#:_____ Fault Category:_____ DQA:_____ Date:_____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date:_____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. C
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	D2174-041	00.07.06 <i>[Signature]</i>
DATE	TITLE		SHEET 1 OF 1
95:10:25	WEB ASSEMBLY		SCALE
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC. <i>[Signature]</i> CP	

RELEASED
00.04.12 *[Signature]*

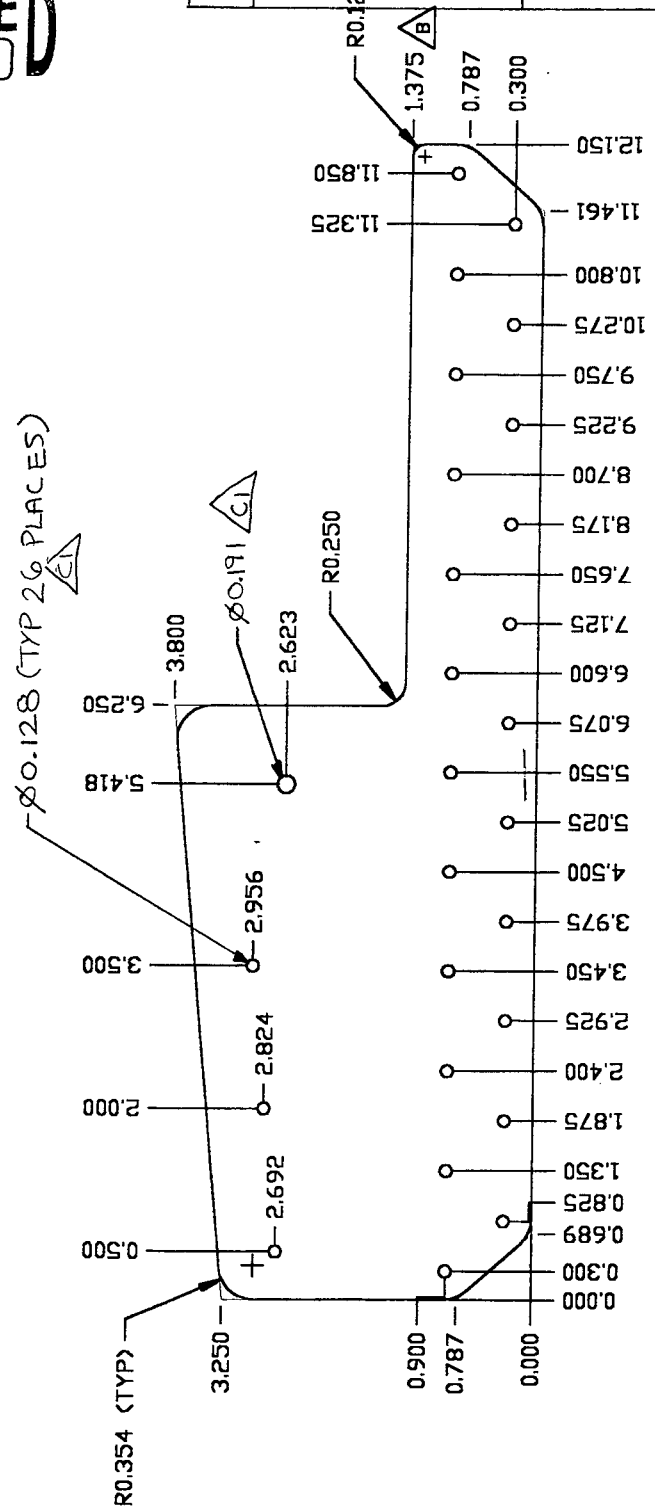
MATERIAL: 2024-T3 (QQ-A-250/5), 0.063 THICK
FINISH: ANODIZE CLEAR POWDER COAT WHITE PER DART QST 005 43.5.1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19365



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. C
CHECKED BWS	APPROVED [Signature]	D2174-1	SHEET 1 OF 1
DATE	TITLE	SCALE	
95:10:25	WEB		
B	96.01.18	RE-DRAWN CHANGED DIMENTION	
C	00.09.11	UPDATE FINISH SPEC. # CP	

RELEASED
00.09.12 #



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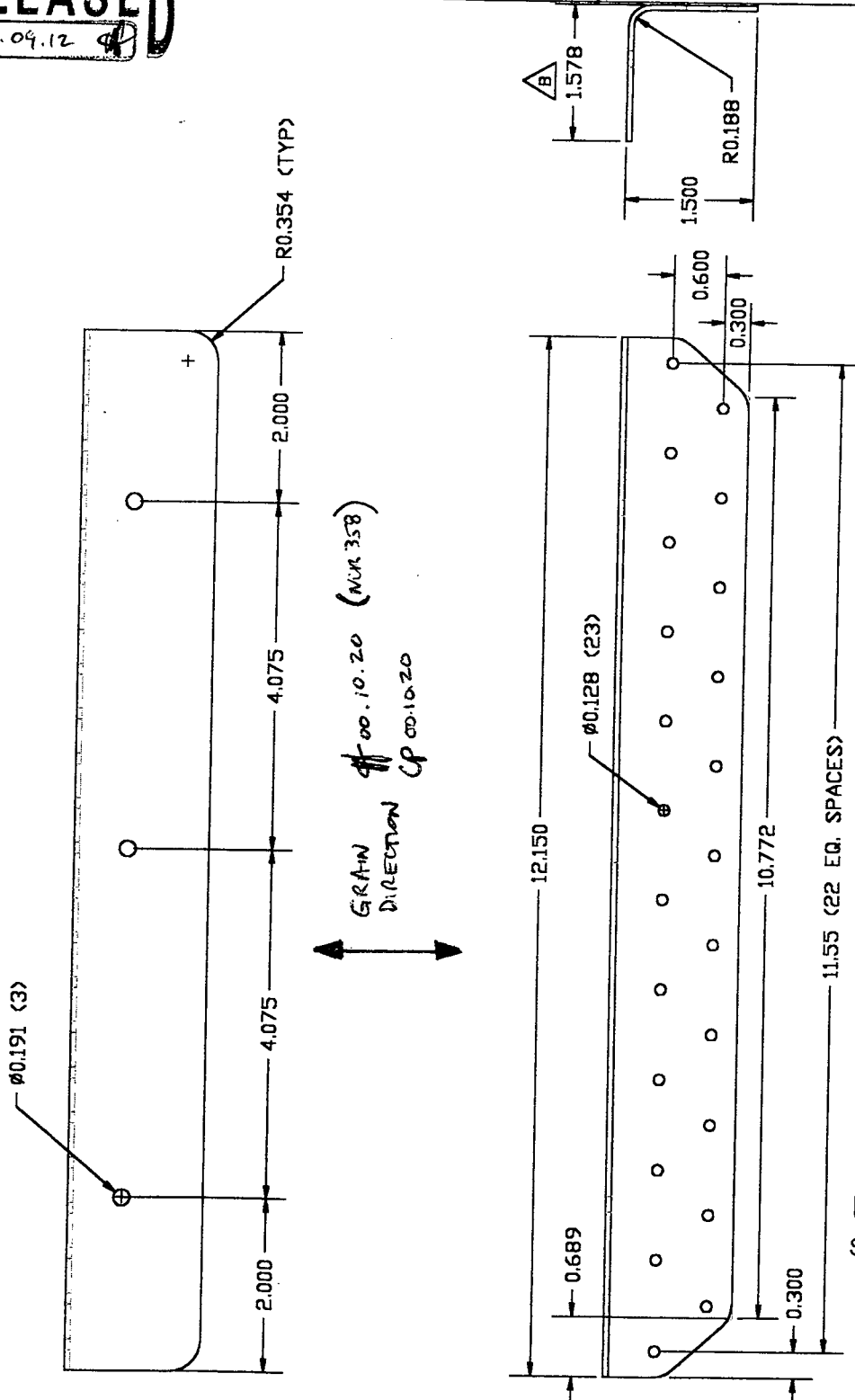
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MATERIAL: 2024-T3 (QQ-A-250/5), 0.063 THICK

C1 01.02.22 ADD HOLE DIMENSIONS # CP



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. #
CHECKED BWS	APPROVED [Signature]	D2175	SHEET 1 OF 1
DATE	TITLE		SCALE
95:10:25	ANGLE		
B	96.01.18	CHANGED DIMENTION	
C	00.09.11	UPDATE FINISH SPEC. [Signature] CP	

RELEASED
00.09.12



MATERIAL: 2024-T3 (QQ-A-250/5), 0.063 THICK
FINISH: ANODIZE CLEAR
CHEMICAL CONVERSION COAT PER DART
QST 005 4.1

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NO. 19365

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 01, 2003
10:58 am

Work Order No : 0019365
Project Name : K10018
Project For : WK328
Work Order Type : Main
Main WO Number :
House Part Number : K10018
Description : Spacepod Hardware Kit
Manufactured : Yes
Amount Req'd : 7
Amount Done : 0
Start Date : 07-01-03
Est Finish Date : 07-05-03
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00		
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00		
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00